

Date: Wednesday, 29/10/2008 8:49:00 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE POSITIONER WELDMENT	
Job Number :	43056			
Estimate Number :	13443			
P.O. Number :		Part Number :	PB674300129	
This Issue :	29/10/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	B6743001 P.40	
First Issue :	1/1	Project Number :	N/A	
Previous Run :	41376	Drawing Revision :	B1	
	Type :	Material :		
	LARGE FAB ASSY	Due Date :	05/11/2008	Qty: 2 Um: Each
Written By :				
Checked & Approved By :	<u>MF 08-10-29</u>			
Comment :	Est Rev:A 08-06-27 new issue DD verified by:ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001313	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Plate
 batch: 41503

MF 08-11-04

2.0	PB6743001319	Gusset
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Gusset
 batch: 40067 x1, 41504 x3.

MF 08-11-04

3.0	PB6743001337	Upper Pad Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Upper Pad Assembly
 batch: 40295 x2, 41506 x2

MF 08-11-04

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 ****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF
 VERTICAL, PRIOR TO WELDING****
 1- ASSEMBLE AND WELD AS PER DWG

CPL 08-11-06

(x2)

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

11/11/14 (2)

Date: Wednesday, 29/10/2008 8:49:01 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER WELDMENT

Job Number: 43056

Part Number: PB674300129

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Inspected



Comment: INSPECT WORK TO CURRENT STEP

Sosulul4 (x2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1



FL 08/11/14 (2)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*11:30
320 OF
12:00*

M-L 08/11/14



(2x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



MF 08-11-14

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST.*



MF 08-11-14

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/11/17

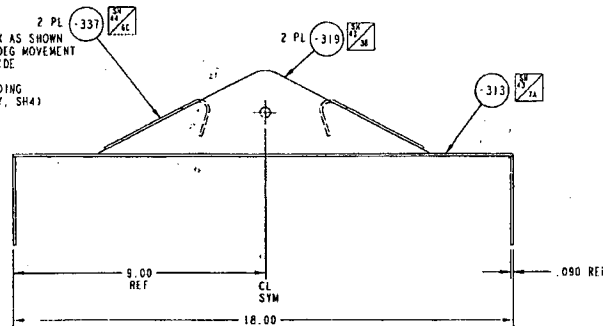
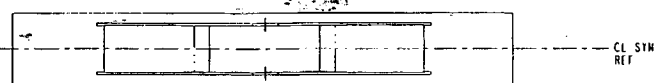
Job Completion



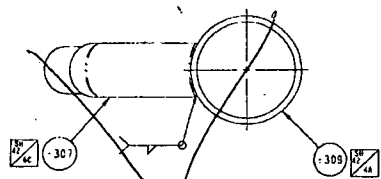
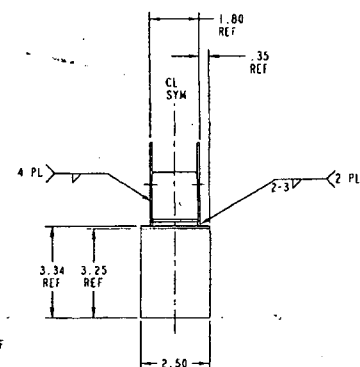
MF 08-11-14

RELEASED
06 01 20

2 PL -337
LOCATE APPROX AS SHOWN
ASSURING 45 DEG MOVEMENT
OF -285 EA SIDE
OF VERTICAL
PRIOR TO WELDING
(SEE -27 ASST, SH4)



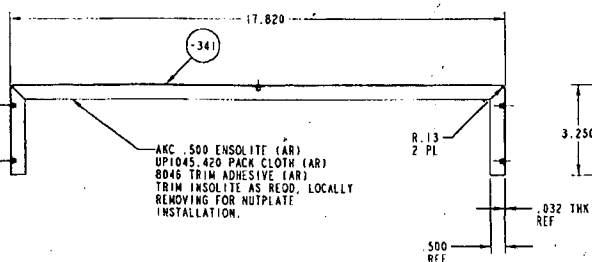
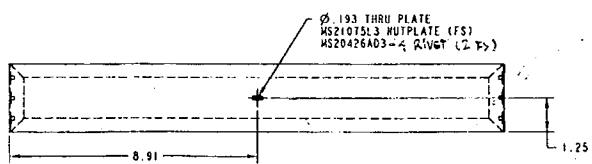
① -29 BLADE POSITIONER WELDMENT
SCALE 0.500



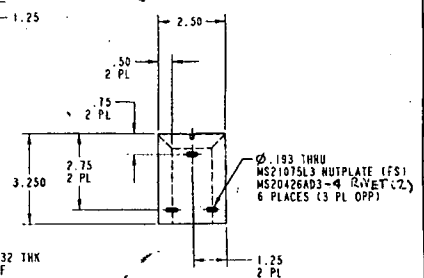
-25 TUBE GUIDE WELDMENT
SCALE 1.000

SUPERCEDED BY
58440-1 & 58440-3

Mo 43056



① -35 LOWER PAD ASSY
SCALE 0.500
MATERIAL FOR -341: .032 THK 2024-T3, 90-A-250/4



PREMIER AVIATION, INC.
3800 Aviation Parkway, Grand Prairie, Texas 75052
SIZE CODE 1341 NO. 032 THK 2024-T3, 90-A-250/4
D OSUV8 B67-43001 B1
SCALE: (N) SHEET: 40 OF 45

ORIGINAL